

Date: Friday, 26/01/2007 1:59:05 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER REVIEW
Job Number : 30482	
Estimate Number : 10836	
P.O. Number : N/A	Part Number : D29391
This Issue : 26/01/2007 S.O. No. : N/A	Drawing Number : D2939 UNDER REVIEW <i>OK</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B <i>67.61.26</i>
Previous Run : 29349	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 12/02/2007 Qty: 6 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: B00.06.26 New DWG rev (mpp 2069) EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Issue material from stock: 7075-T7351 QQ-A-250/12
Cut Size 2.0 x 6.25 X 6.00
Grain Along Long 6.00 Length
Batch No: *1325343* *SA*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
5-Deburr *SA 07.01.25* *(G)*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet *SA 07/02/02*

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET *SA 07.01.25* *(G)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.01.26	2	TOOL RAD FOR FLANGE POCKETS SHOULD BE R.D. 188				 07.01.26 PS	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PO Date: 07/01/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/25	2	flange of saddle is .094. should be between .140-.100 .006. under tol.	 PS 07.01.25 07/01/25	Part acceptable. Immediately adjust offset.	SD 07.01.25	 07.01.25	 PS 07.01.25 07/01/25	 07.01.25

NOTE: Date & initial all entries

Date: Friday, 26/01/2007 1:59:05 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER
REVIEW

Job Number: 30482

Part Number: D29391

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

m 07/02/05 6

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

LL 1

07/02/06 6

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ATTN: PAINT 1 pc grey

M 103141

(6x)

m. g/yl

07/02/08

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/02/09 CU

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *51482*

07/02/09 6x CU

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/12 6

Job Completion



LL 07.02.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30482
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.124	.124	.123		
B	0.100	0.140		.122	.123	.124	.124		
C	0.100	0.140		.123	.122	.122	.120		
D	0.210	0.230		.218	.218	.218	.217		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.574	1.574	1.574	1.574		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	.258	.258	.258	.258		
L	0.312	0.317	DT8686	.314	.314	.314	.314		
M	0.235	0.240		0.240	0.239	0.239	0.239		
N	0.100	0.140		.119	.119	.119	.117		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.500	.500	.499	.498		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.742	2.742	2.742	2.742		
S	0.240	0.270		.251	.252	.251	.252		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	.320	.320	.320	.320		
X	1.250	1.270		1.258	1.257	1.257	1.258		
Y	1.565	1.585	DT8695 A/B	1.573	1.572	1.572	1.573		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD	Audited by: Jml
Date: 07.01.28	Date: 07/02/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 30482
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

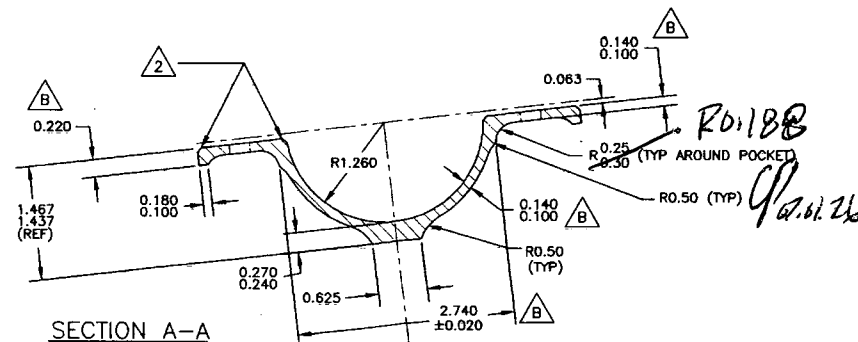
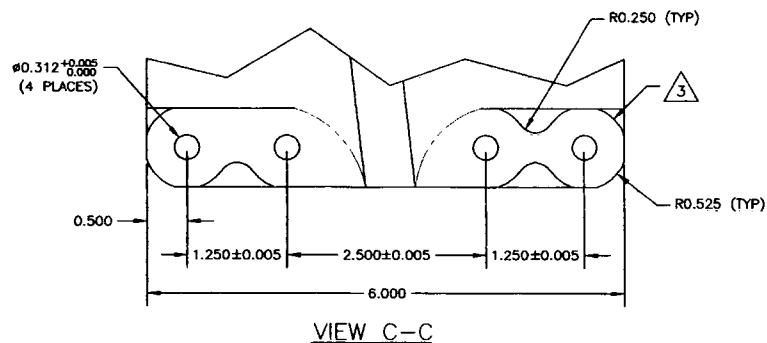
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.122	.125				
B	0.100	0.140		.122	.127				
C	0.100	0.140		.122	.125				
D	0.210	0.230		.218	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.508				
H	0.510	0.515		0.510	0.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262	DT8682	.258	.258				
L	0.312	0.317	DT8686	.314	.314				
M	0.235	0.240		0.239	0.239				
N	0.100	0.140		.116	.119				
O	0.540	0.560		.548	.546				
P	0.490	0.510		.497	.477				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.742	2.742				
S	0.240	0.270		.251	.261				
T	0.100	0.180		.170	.170				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690	.320	.320				
X	1.250	1.270		1.257	1.252				
Y	1.565	1.585	DT8695 A/B	1.572	1.568				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	SD
Date:	07.01.29

Audited by:	me
Date:	07/02/05

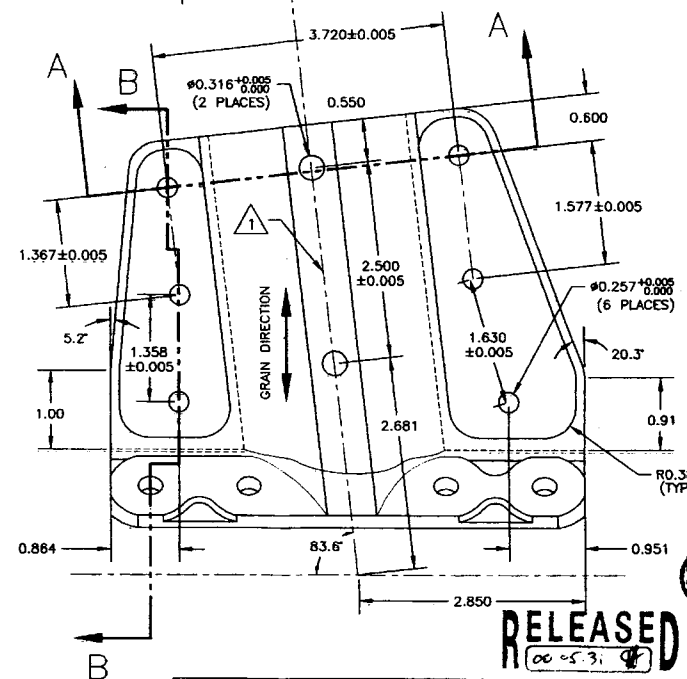
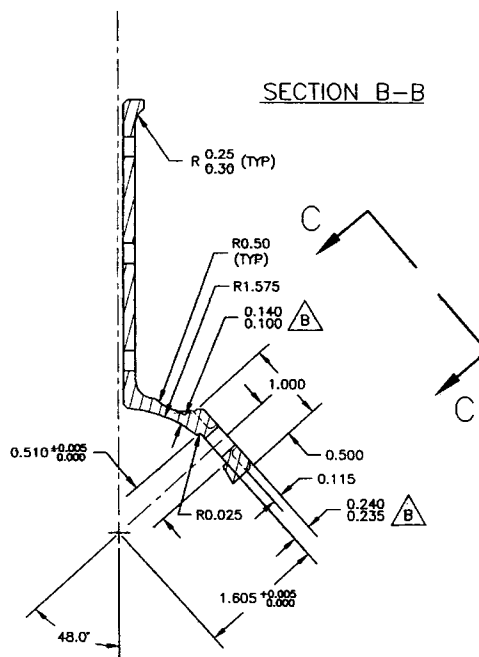
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



UNDER REVIEW

06.11.09 cb

change R0.25

RELEASED
 00-531

B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLVALE, WA
CHECKED	APPROVED	DRAWING NO. D2939
DATE	00.05.29	TITLE SADDLE INSIDE
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		REV. B SHEET 1 OF 1 SCALE 2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 19, 2006 3:31 PM
To: 'S Shahbazian'
Cc: 'Provencal, Chris'; 'Charbonneau, Eric'
Subject: RE: Radius dimension on the saddle
Importance: High

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.
See D2661 to D2668 as well as D2932 to D2933.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Thursday, October 19, 2006 1:16 PM
To: Shepherd, David
Cc: Provencal, Chris; Charbonneau, Eric
Subject: Radius dimension on the saddle

Dave,
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188 since the tooling has been changed long time ago, and apparently they have been machining those radiuses to 0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the changes.

Serge

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

--
No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006